

# Work Order ID 62022

Wednesday, September 15, 2010 10:02:15 A



Page 1

Item ID: D3278-2

Accept



Setup Start



Revision ID:

Stop



Item Name: Support

Start Date: 9/14/2010 Start Qty: 20.00



Cust Item ID:

Required Date: 9/21/2010 Req'd Qty: 20.00

Customer:

Reference:

Approvals:

Process Plan:

*Handwritten signature*

Date: 10-9-15 Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3278

Rev C

100

0.00



SHEAR

Shear

Memo

0.00

Shear

Cut blank: 2.00" x 1.00" x 2.550" long

*Handwritten: OK 10/09/22*

*Handwritten: 20*

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1- Machine as per Folio FA405 and Dwg D3278-2- Deburr and Tumble Identify as D3278-2

*Handwritten: SN 10/11/03*

*Handwritten: 21*

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

*Handwritten: SN 10/11/03*

*Handwritten: 21*

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Work Order ID 62022

Wednesday, September 15, 2010 10:02:15 A

Page 2

Item ID: D3278-2

Accept

Revision ID:

Item Name: Support

Start Date: 9/14/2010 Start Qty: 20.00

Required Date: 9/21/2010 Req'd Qty: 20.00

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME: 11:25 OVEN TEMPERATURE:  
FINISH TIME: 11:55

amf 10/11/04

21 0

21 BR 10-11-4

21 BR 10-11-9

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Work Order ID 62022

Wednesday, September 15, 2010 10:02:15 A

Page 3

Item ID: D3278-2

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Revision ID:

Item Name: Support

Start Date: 9/14/2010 Start Qty: 20.00

Required Date: 9/21/2010 Req'd Qty: 20.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

=> 94 10/4/09 21 0

170

Identify as per dwg & Stock Location: 645

0.00



Packaging

Memo

0.00

Packaging

10/11/10 (2)

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/10/10 10-11-10

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, September 15, 2010 10:02:20 AM

Page 1

Work Order ID: 62022



Parent Item: D3278-2



Parent Item Name: Support

Start Date: 9/14/2010

Required Date: 9/21/2010

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP: ☐ A ☐ 04.04.19 ☐ New issue ☐ KJ/JLM ☐  
IPP B 07.09.06 Rev C dwg EC Verified by: JLM

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Qty per Kit | Total<br>Qty | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| M6061T6B1.000X02.00<br>0        |                        | Purchased     | No          |                     |                  | 100             | f                  | 35.6620        | 0.2337      | 4.92         |               |                |        |



6061-T6 Bar 1.00 x 2.00

| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
| MAT             | 33.432         |                 |
| 112567          | 0              |                 |
| → 115045        | 33.432         |                 |
| MAT03           | 2.23           |                 |
| 112567          | 2.23           |                 |

4.92" mfk 10/01/22

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
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| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



|                              |               |                     |         |
|------------------------------|---------------|---------------------|---------|
| <b>DART AEROSPACE LTD</b>    |               | <b>Work Order:</b>  | 62022   |
| <b>Description:</b> Support  |               | <b>Part Number:</b> | D3278-2 |
| <b>Inspection Dwg:</b> D3278 | <b>Rev:</b> C | <b>Page 1 of 1</b>  |         |

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

| Drawing Dimension | Tolerance     | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|---------------|------------------|--------|--------|----------------------|----------|
| Ø0.098            | +0.005/-0.000 | 0.100            | /      |        | Vern                 | SA-9     |
| 0.359             | +/-0.005      | 0.359            | /      |        | Vern                 |          |
| 0.609             | +/-0.010      | 0.612            | /      |        | Vern                 |          |
| 0.250             | +/-0.010      | 0.250            | /      |        | Vern                 |          |
| 1.480             | +/-0.005      | 1.480            | /      |        | Vern                 |          |
| R0.125            | +/-0.010      | R.125            | /      |        | Gage                 |          |
| 0.119             | +0.005/-0.004 | 0.122            | /      |        | Vern                 |          |
| 2.439             | +/-0.010      | 2.439            | /      |        | Vern                 |          |
| 1.980             | +/-0.010      | 1.982            | /      |        | Vern                 |          |
| R0.13             | +/-0.030      | R.13             | /      |        | Gage                 |          |
| Ø0.257            | +0.005/-0.000 | 0.258            | /      |        | Vern                 |          |
| R0.375            | +/-0.010      | R.375            | /      |        | Gage                 |          |
| 0.875             | +/-0.010      | 0.875            | /      |        | Vern                 |          |
| 0.500             | +/-0.010      | 0.499            | /      |        | Vern                 |          |
| R0.400            | +/-0.010      | R.400            | /      |        | Gage                 |          |
| R1.00             | +/-0.030      | R.100            | /      |        | Gage                 |          |
| 1.720             | +/-0.010      | 1.720            | /      |        | Vern                 |          |
| R0.125            | +/-0.010      | R.125            | /      |        | Gage                 |          |
| 0.125             | +/-0.010      | 0.125            | /      |        | Vern                 |          |

|                     |          |                    |          |                            |     |
|---------------------|----------|--------------------|----------|----------------------------|-----|
| <b>Measured by:</b> | SA       | <b>Audited by:</b> | AM       | <b>Prototype Approval:</b> | N/A |
| <b>Date:</b>        | 10/11/03 | <b>Date:</b>       | 10/11/04 | <b>Date:</b>               | N/A |

| Rev | Date     | Change                            | Revised by | Approved |
|-----|----------|-----------------------------------|------------|----------|
| A   | 04.04.19 | New Issue P/O D3278-041           | KJ/JLM     |          |
| B   | 05.06.08 | 0.359 was 0.365; 0.119 was 0.125  | KJ/JLM     |          |
| C   | 07.09.26 | Dimensions updated per Dwg Rev. C | KJ/EC      | BE       |

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

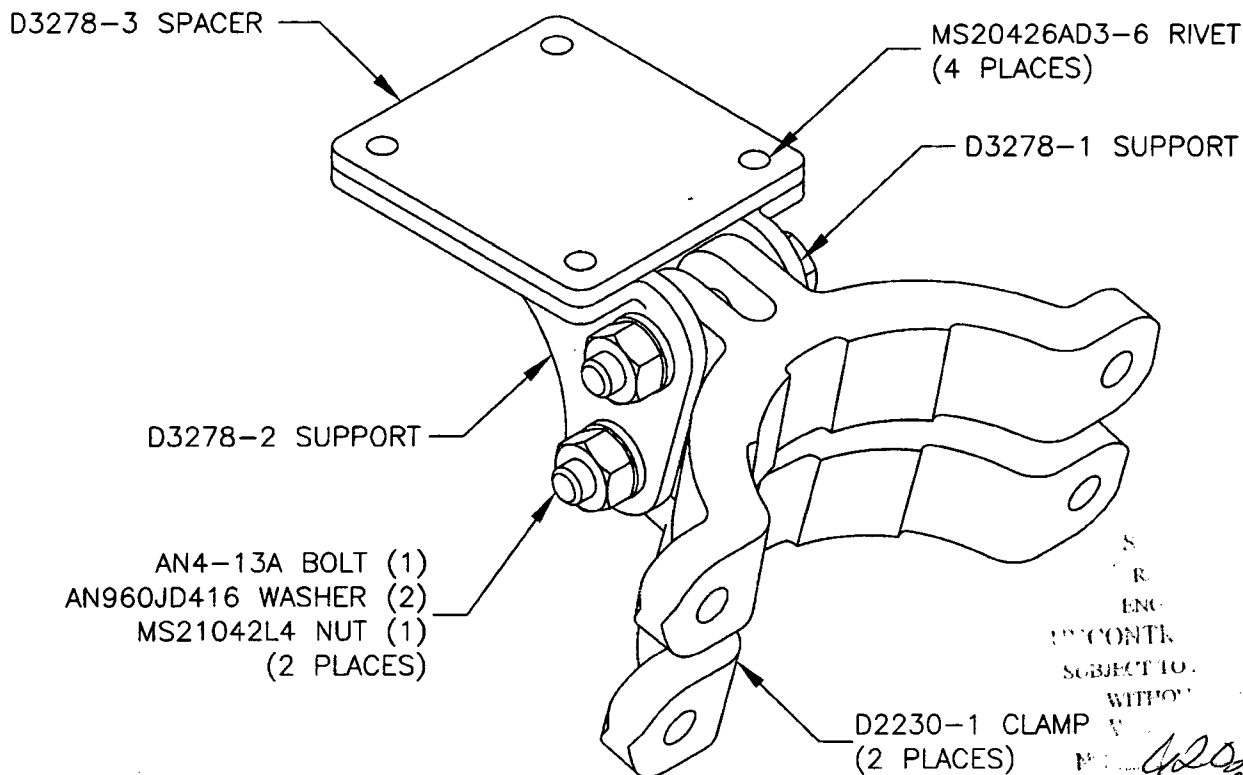
**NOTE:** Date & initial all entries



|                  |                |   |                        |
|------------------|----------------|---|------------------------|
| DESIGN<br>97     | DRAWN BY<br>BC | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |                        |
| CHECKED<br>B     | APPROVED<br>H  | DRAWING NO.<br>D3278                              | REV. C<br>SHEET 1 OF 3 |
| DATE<br>07.07.24 |                | TITLE<br>SUPPORT ASSEMBLY                         | SCALE<br>NTS           |
| A                | 04.03.03       | NEW ISSUE   |                        |
| B                | 05.03.31       | CHANGE DIM/TOL TO ENSURE FIT                      |                        |
| C                | 07.07.24       | CHANGED RIVETS PER PAR #185                       |                        |

RELEASED  
07-08-08

## D3278-041 SUPPORT ASSEMBLY



| Qty | Part Number  | Description      |
|-----|--------------|------------------|
| X   | D3278-041    | SUPPORT ASSEMBLY |
| 2   | D2230-1      | CLAMP            |
| 1   | D3278-1      | SUPPORT          |
| 1   | D3278-2      | SUPPORT          |
| 1   | D3278-3      | SPACER           |
| 2   | AN4-13A      | BOLT             |
| 4   | AN960JD416   | WASHER           |
| 4   | MS20426AD3-6 | RIVET            |
| 2   | MS21042L4    | NUT              |

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| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

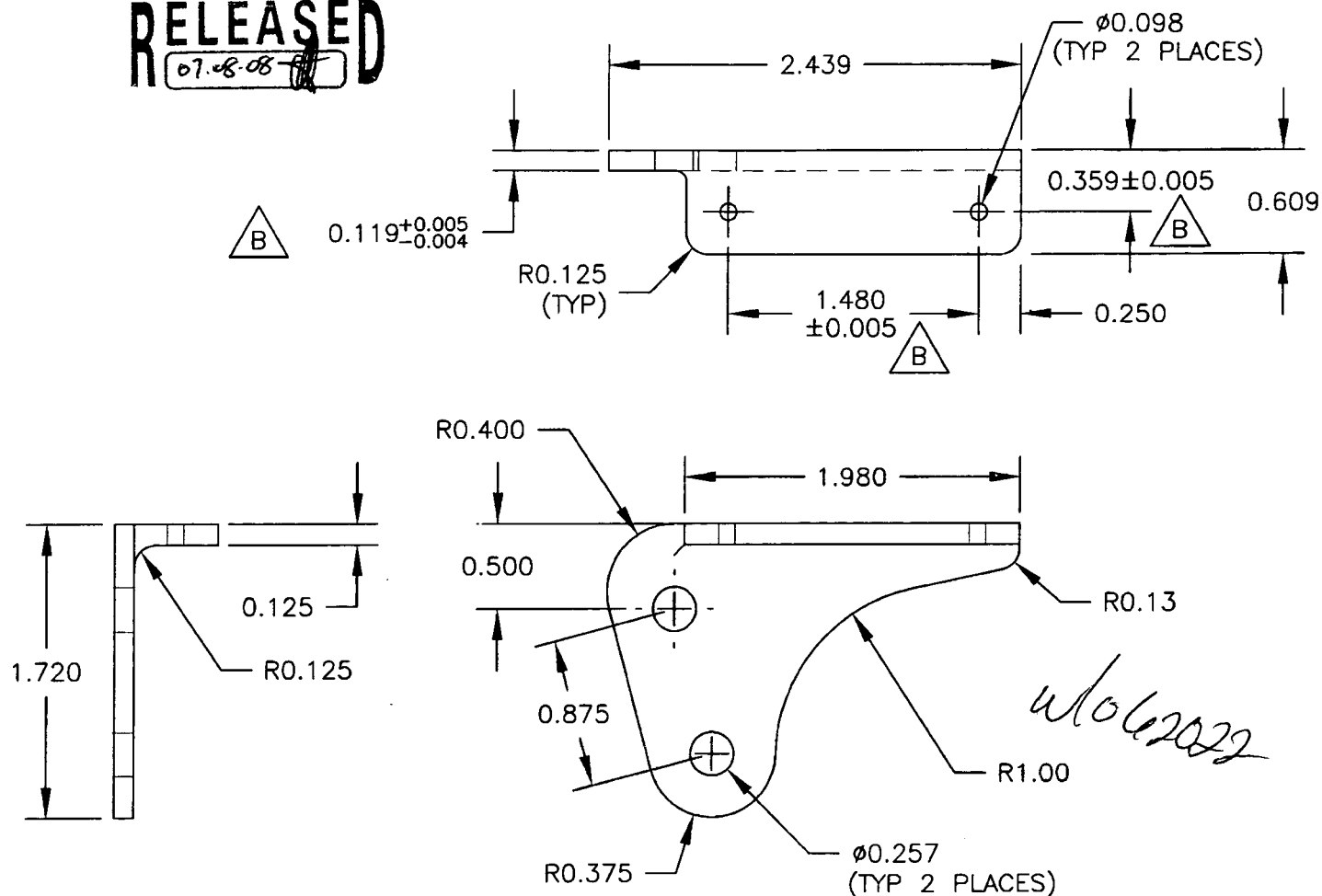
| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
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|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



|                     |                       |   |                        |
|---------------------|-----------------------|---|------------------------|
| DESIGN<br><i>92</i> | DRAWN BY<br><i>BC</i> | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |                        |
| CHECKED<br><i>B</i> | APPROVED<br><i>H</i>  | DRAWING NO.<br>D3278                              | REV. C<br>SHEET 2 OF 3 |
| DATE<br>07.07.24    |                       | TITLE<br>SUPPORT ASSEMBLY                         | SCALE<br>1:1           |

RELEASED  
07-08-08



**D3278-1 SUPPORT (SHOWN)**

**D3278-2 SUPPORT (OPPOSITE)**

- 1) MACHINE PER DWG FILE "D3278-1.SLDPRT"
- 2) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)  
PER AMS-QQ-A-200/8 (OR AMS 4160)  
(REF. DART SPEC. M6061T6B)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

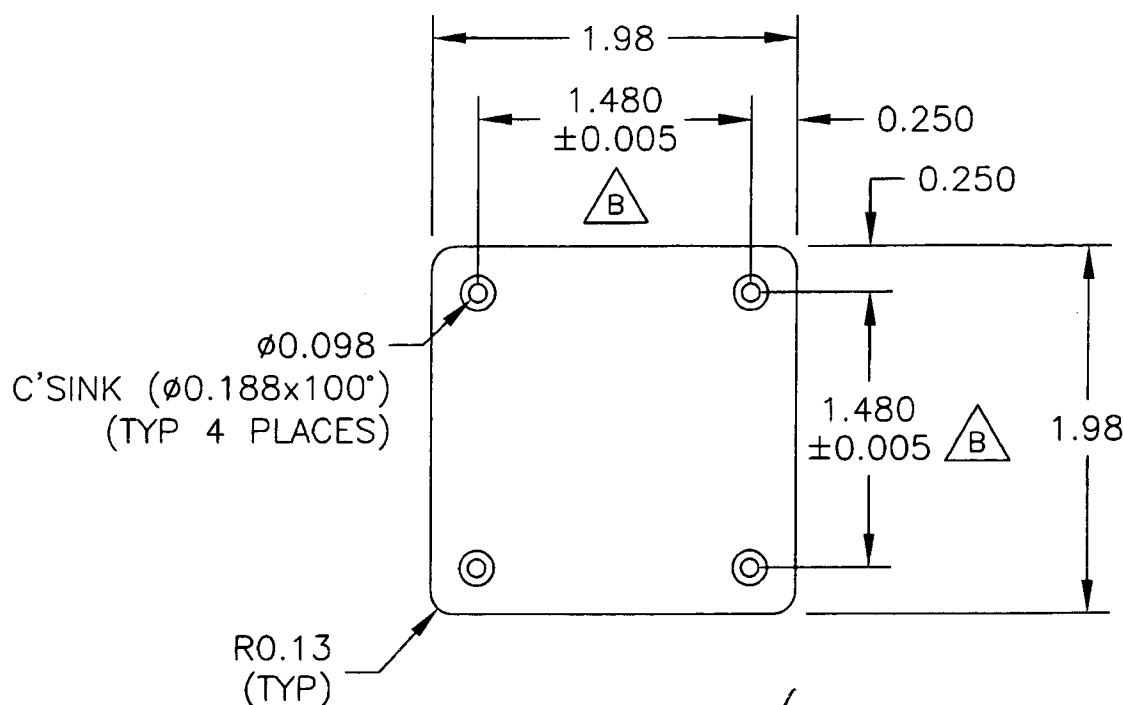
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|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



|                     |                                |   |                        |
|---------------------|--------------------------------|---|------------------------|
| DESIGN<br><i>GP</i> | DRAWN BY<br><i>DC</i>          | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |                        |
| CHECKED<br><i>B</i> | APPROVED<br><i>[Signature]</i> | DRAWING NO.<br>D3278                              | REV. C<br>SHEET 3 OF 3 |
| DATE<br>07.07.24    |                                | TITLE<br>SUPPORT ASSEMBLY                         | SCALE<br>1:1           |

RELEASED  
07.08.08



### D3278-3 SPACER

- 1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL  
(REF. DART SPEC. M-DELRIN-B0.125x2.000) OR  
DELRIN II 150E OR ACETRON GP ACETAL  
(REF. DART SPEC. M-DELRIN-S.125)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries